

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012654**Date Inspected:** 01-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SMAW welding of weld joint SD1-A440E/E-38 located on PCMK south tower, skirt assembly. Welders were identified as 052493, 040581. ZPMC QC was identified as CWI Gong Liang Zhu (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-P-2314-B-P3.

SMAW welding of weld joint SSD1-TL5-1B-F-39B located inside PCMK south tower, lift 5. Welders were identified as 052930, 053049. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QC Jiang Xiao Bo. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-3212-TC-U4b-1. Also present at this location and appearing to be monitoring the welding related operations were ABF Representative Yang Ye Heng.

Bay 11

This QA Inspector randomly observed no apparent welding related work being performed in Bay 11.

Heavy Dock

This QA Inspector randomly observed the following work in progress on the Heavy Dock:

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North tower, lift 2 was suspended from the ZPMC 1600 ton floating crane while in position on top of north tower, lift 1. ZPMC workers were manually installing and removing bolts at the lift 1/lift 2 splice plates of all 5 skin plates.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest, 150-0042-2360, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
